

**Work Order ID 66239**

Page 1

February 8, 2011 8:43:49 AM

Item ID: D3531-3

Accept



Setup Start



Revision ID:

Item Name: Bracket Front Plate

Stop



Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CZDate: 11/02/08

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3531	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

B 11-2-16

FLOW CNC Waterjet

66231 . 040

I-Cut as per Dwg D3531  
Dwg Rev: A  
Prog Rev: A  
2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B 11-2-16

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

Small Fab



Small Fab

Memo

Deburr if necessary.

140



NC BRAKE

0.00

0.00

Brake NC

Memo

Bend as per Dwg D3530

150



QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

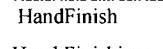
Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

9 p 11 02/23

Hand Finishing

170



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

9 BR 11-223,

180

Identify as per dwg & Stock Location: 6A

0.00

Packaging

Packaging

Memo

0.00

ES 11/02/23 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 4

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Item Name: Bracket Front Plate

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Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/02/23 JF

MF

11-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

February 8, 2011 8:43:48 AM

Work Order ID: 66239



Parent Item: D3531-3



Parent Item Name: Bracket Front Plate

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	50.3300	0.1313	0.552842	1.2		

6061-T6 .040 Sheet



Location	Loc Qty	Loc Code
MAT21	50.33	
111224	0.4	
113004	49.93	113004

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46239
Description: Bracket Front Plate	Part Number:	D3531-3
Inspection Dwg: D3531 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

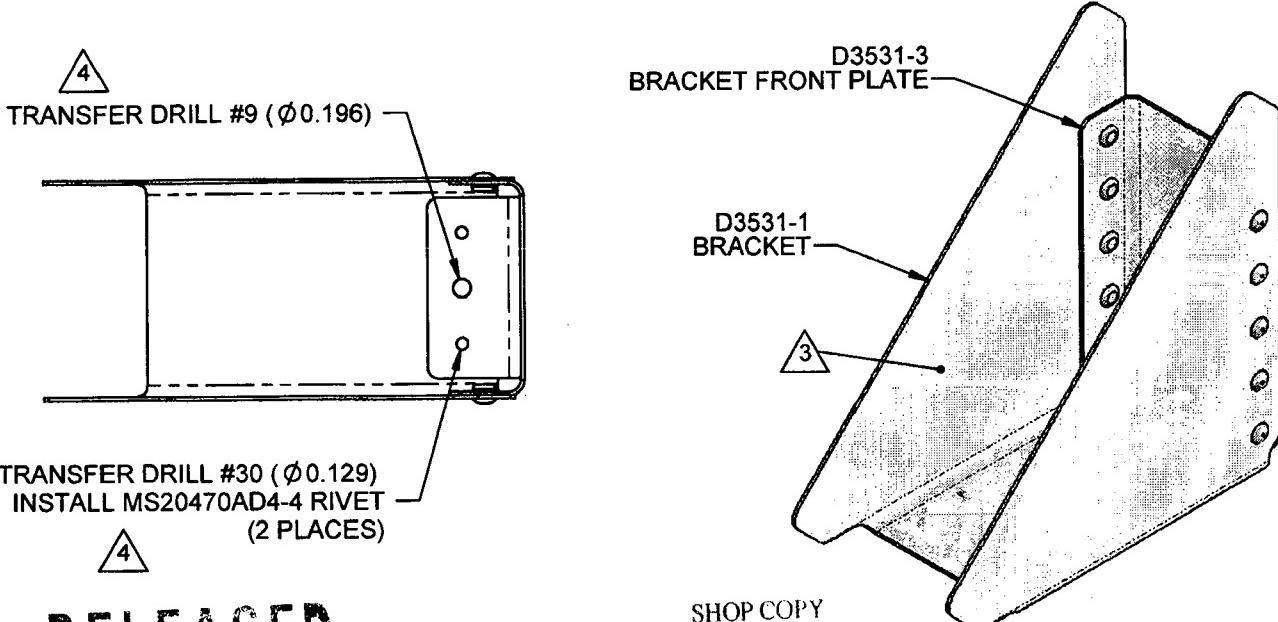
## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-2-16	Date:	11/02/16	Date:	N/A

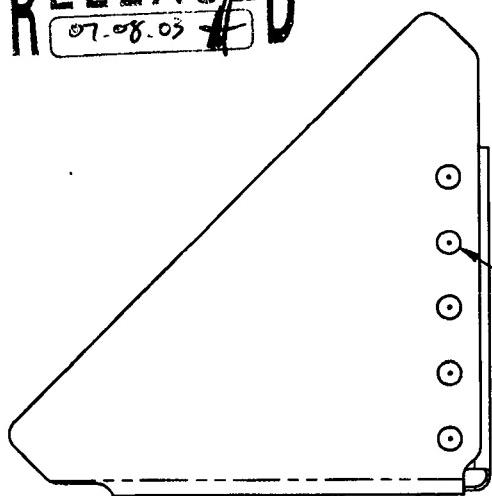
Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	DS

**DART**

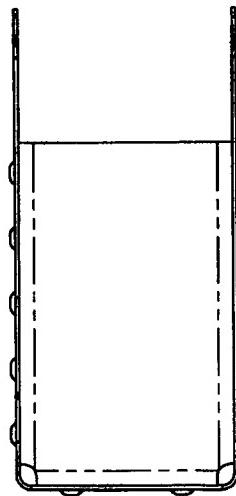
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>SH</i>	DRAWING NO. <b>D3531</b>
DATE <b>07.06.19</b>		REV. A SHEET 1 OF 3
		SCALE 1:2
REV <b>A</b>	DATE <b>07.06.19</b>	DESCRIPTION <b>NEW ISSUE</b>



**RELEASED**  
07-08-03



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WORK ORDER  
NO. 666239  
CZ 1102108



### D3531-041 BRACKET ASSEMBLY

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK  
SANTEX (4.3.5.7) PER DART QSI 005 4.3  
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING  
WHITE MARKER ON INSIDE OF BRACKET  
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET  
THROUGH D3531-3 BRACKET FRONT PLATE  
BEFORE FINISHING

#### PARTS LIST

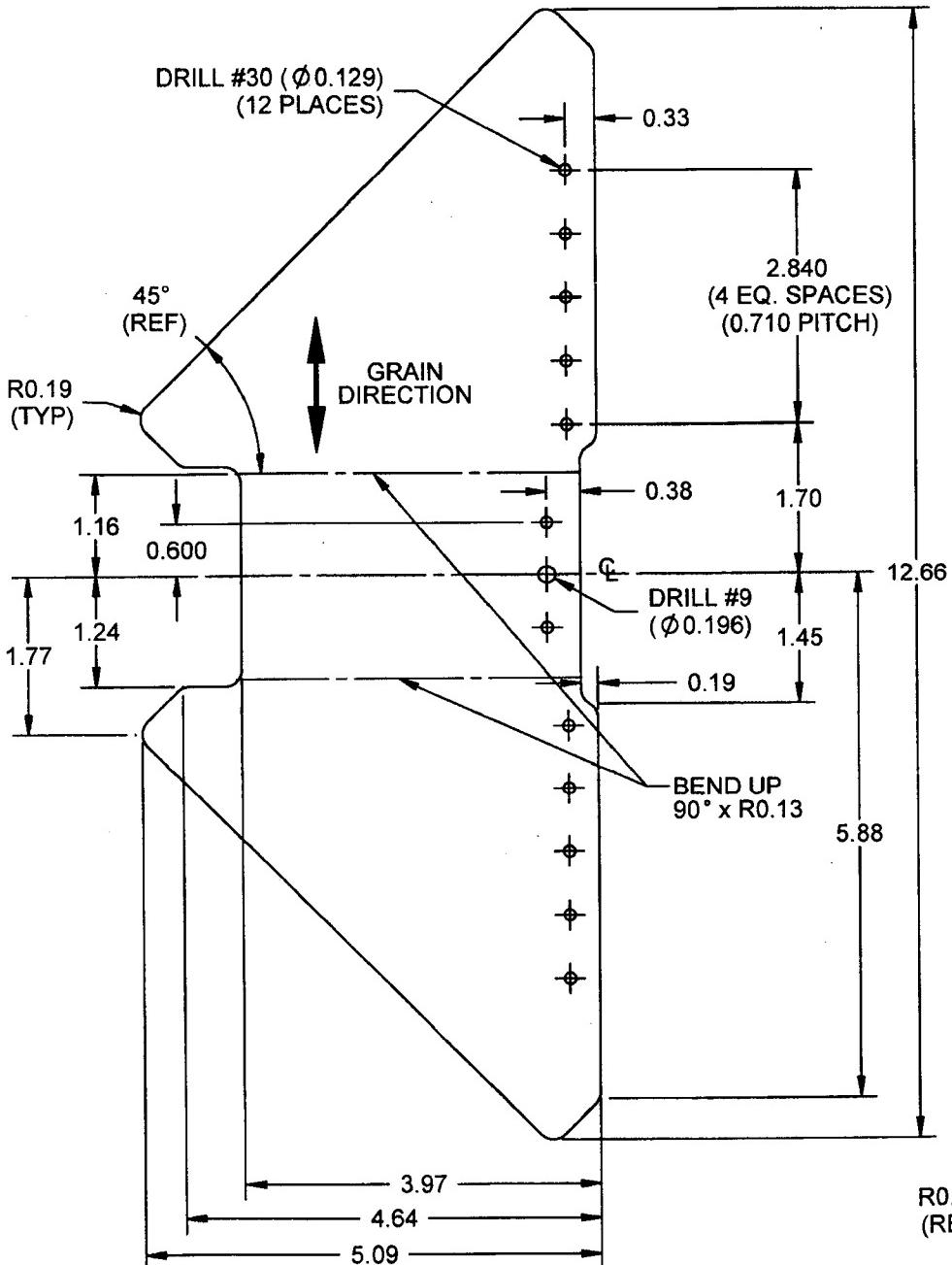
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3531</b>	REV. A	SHEET 2 OF 3
DATE <b>07.06.19</b>	TITLE <b>BRACKET ASSEMBLY</b>	SCALE <b>1:2</b>		



## **D3531-1F FLAT PATTERN**

**NOTES:**

- NOTES:**

  - 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
  - 6) PART IS SYMMETRIC ABOUT  $\varnothing$

D3531-1 BRACKET

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## WORK ORDER

66239

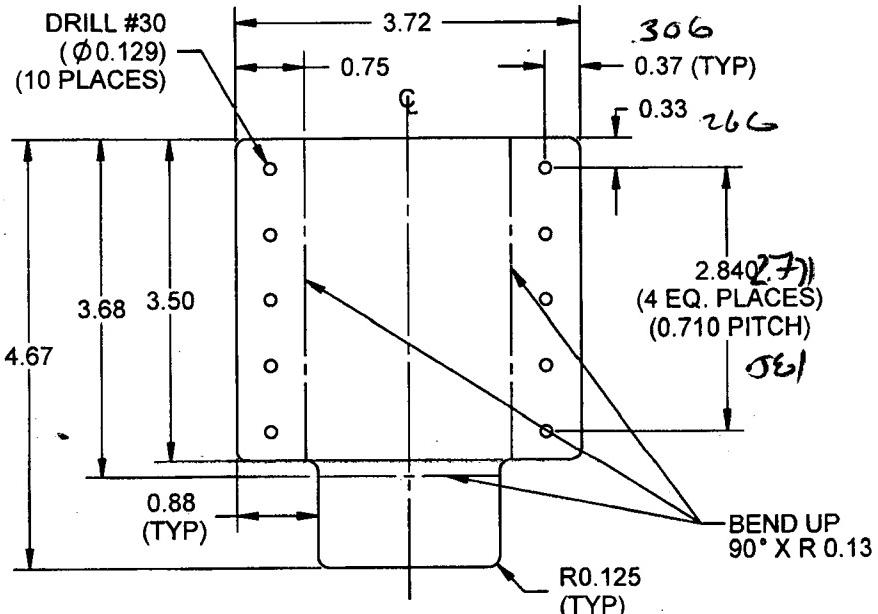
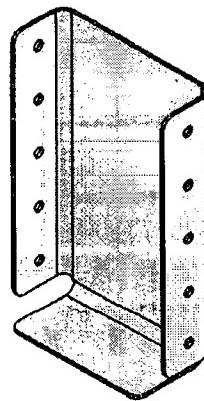
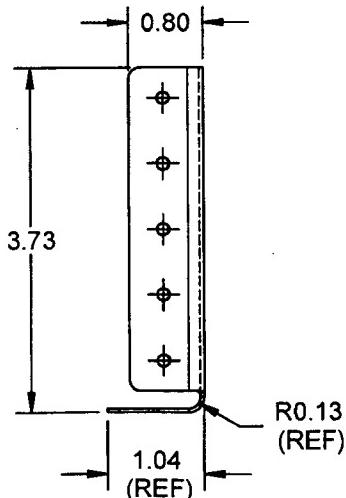
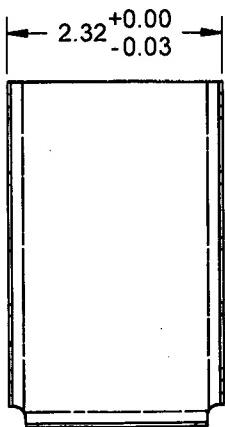
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CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3531</b>
DATE 07.06.19	TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
07.08.03**D3531-3F FLAT PATTERN****D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q

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